



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2600-3-BENT-LH Job Sheet 209538



Part No: D2600-3-BENT-LH

Job Qty: 10 pcs

Part Name: Extrusion Bent LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/20

Job Tracking No:

Due Date: 8/10/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2750 REV C SHEET 4, D2600 REV E SHEET 2 IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - Bend - 1	10 pcs	8/10/20	8/10/20	0.20	3.22	Skidtubes - Bend		03 9-89
110	QC 5	10 pcs	8/10/20	8/10/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
120	Packaging 3-1 - Stock - B4B	10 pcs	8/10/20	8/10/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		

Plex 5/1/20 2:33 PM Dart.lajeunesse.marie



Container No: S281561



Part: D2600-3-BENT-LH

Job No: 209538

Serial No/Batch: S281561

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/05/20

					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
					Packaging 3 - 18 - B4B					
					Packaging 3 - 19 - B4B					
					Packaging 3 - 20 - B4B					
					Packaging 3 - 21 - B4B					
					Packaging 3 - 22 - B4B					
					Packaging 3 - 23 - B4B					
					Packaging 3 - 24 - B4B					
					Packaging 3 - 25 - B4B					
					Packaging 3 - 26 - B4B	TF June 30, 2020				
					Packaging 3 - 27 - B4B					
					Packaging 3 - 28 - B4B					
					Packaging 3 - 29 - B4B					
					Packaging 3 - 30 - B4B					
					Packaging 3 - 31 - B4B					
					Packaging 3 - 32 - B4B					
					Packaging 3 - 33 - B4B					
					Packaging 3 - 34 - B4B					
					Packaging 3 - 35 - B4B					
					Packaging 3 - 36 - B4B					
					Packaging 3 - 37 - B4B					
					130 QC 21 - SA	10 pcs	8/10/20	0.00 0.00	QC 21 - SA - 21	
									QC 21 - SA - 53	JUN 30 2020
										DAS 77

Part Op 100 - (CNC Delta 100 Bender) Pick qty 1 D2600-3-130 extrusion 1-Deburr one end of extrusion 2-Bend using CNC
 Descriptions: bending machine as per program 2750.C and Folio 14 use bending aid DT9635 3- cut fwd end of tube as per dwg D2750
 4- cut aft end of tube as per dwg D2750
 110 - (QC5- Inspect part completeness to step on W/O)
 120 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002
 130 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-130	Extrusion Round 3" 350	10 pcs (1 ea)	100-Skidtubes - Bend - 1	5251561

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - Bend - 1	D2600-3-130	10	130	0

Part Specifications

Specifications could not be found.

Plex 5/1/20 2:33 PM Dart.lajeunesse.marie

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN8C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

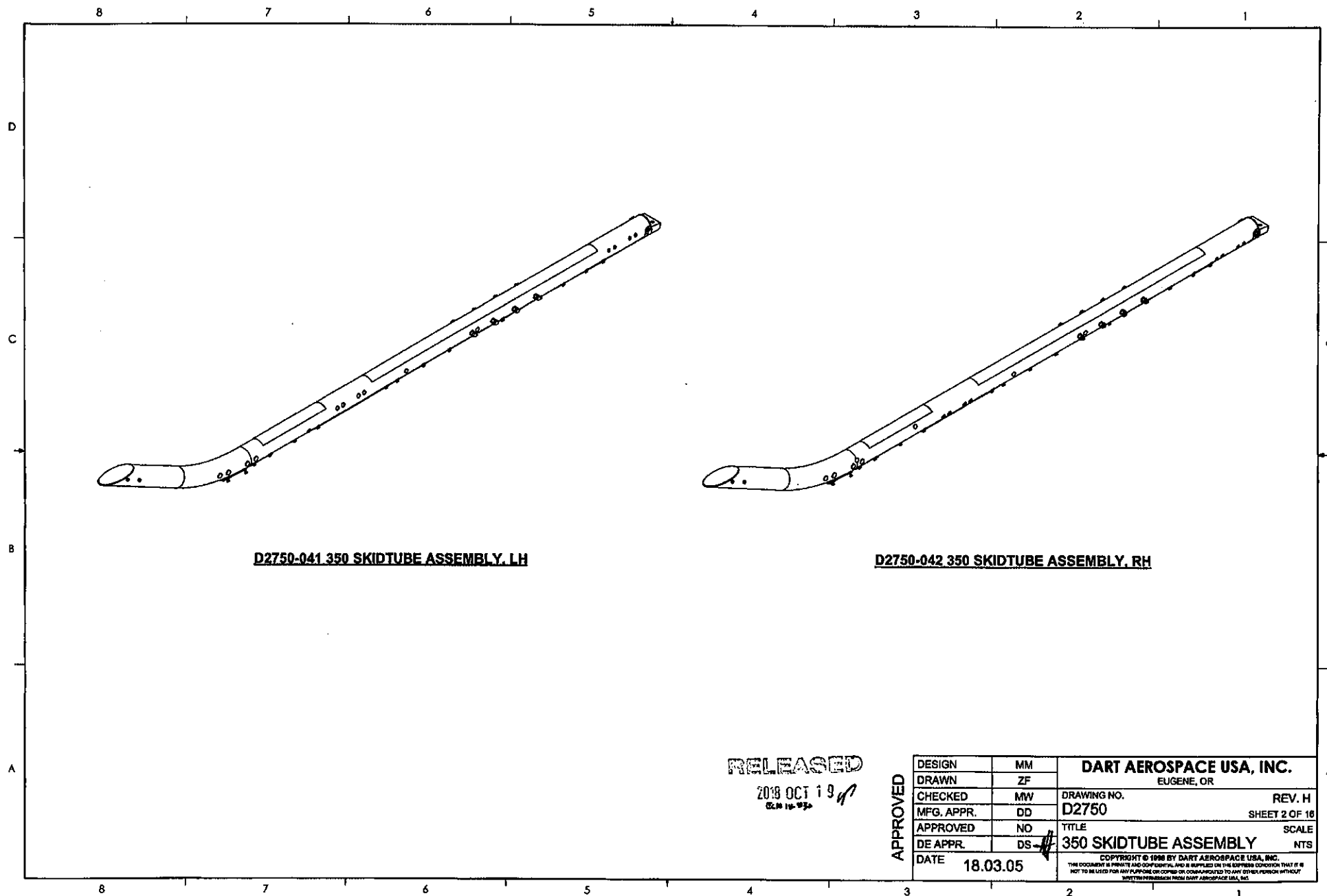
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2018-08-06

H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-5/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B8-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN980C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0832R REPLACES AN980C818L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.01/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3532-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A8-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN980C818; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	06.11.18
B	CHANGE MS24694-S203 TO AN8-16A	CP	06.09.01
A	NEW ISSUE	DS	06.04.16
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CHECKED	MW	DRAWING NO.	REV. H
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APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

D

C

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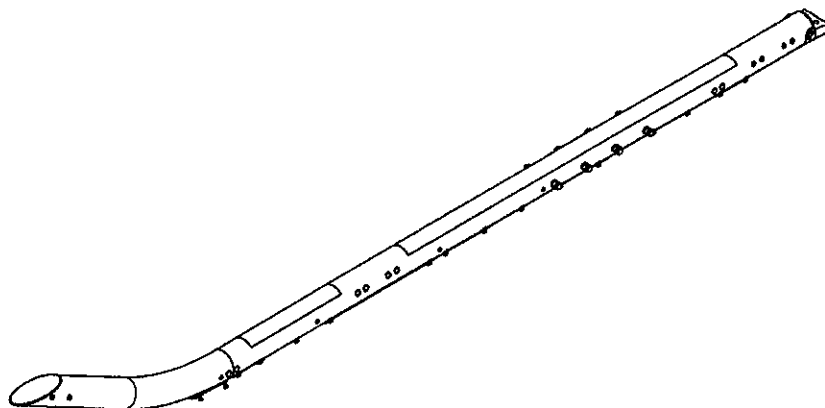
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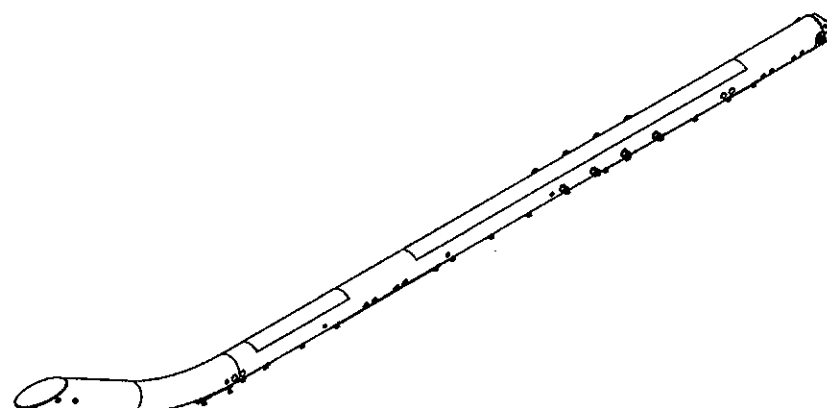
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

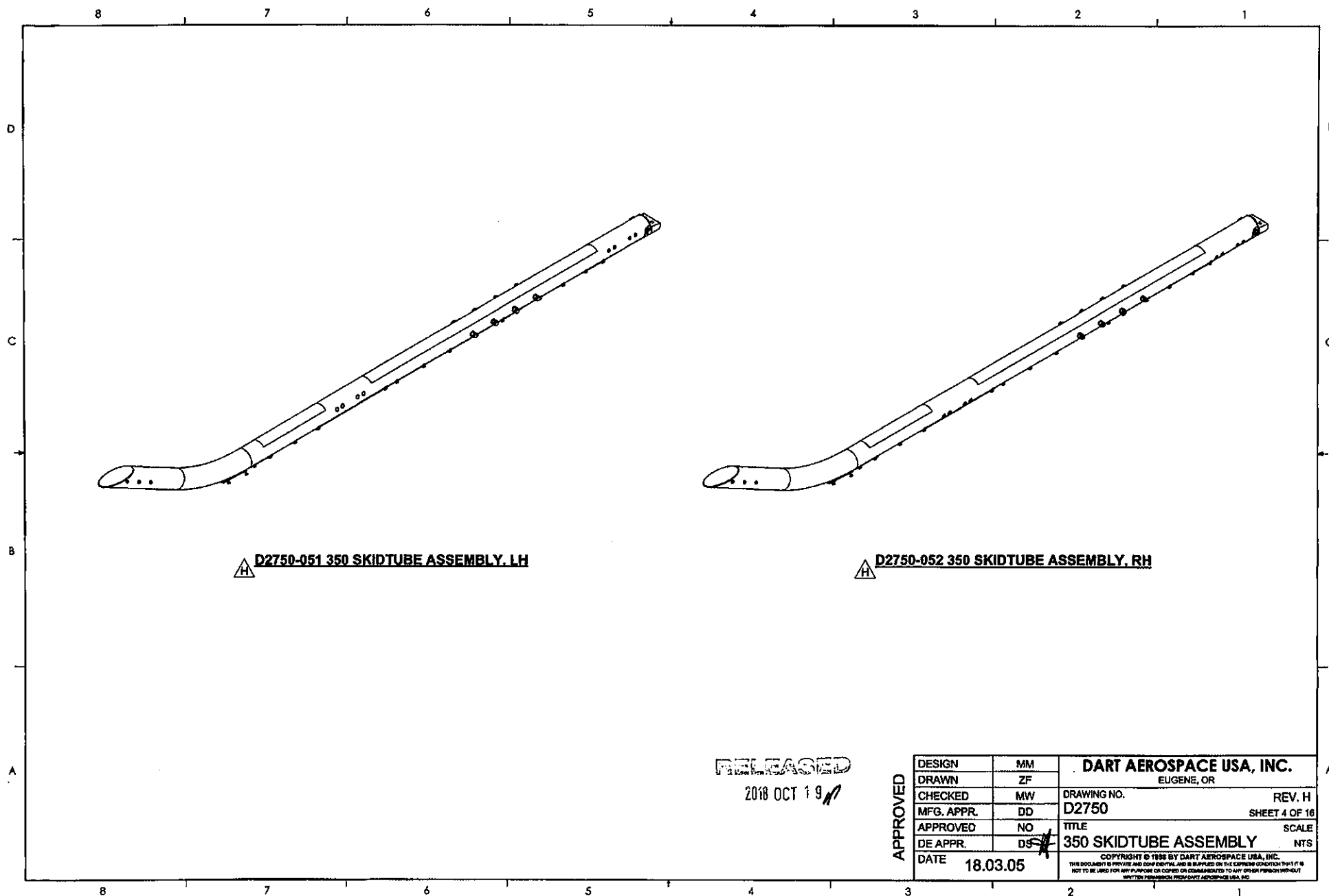
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8 7 6 5 4 3 2 1



D2750-051 350 SKIDTUBE ASSEMBLY, LH

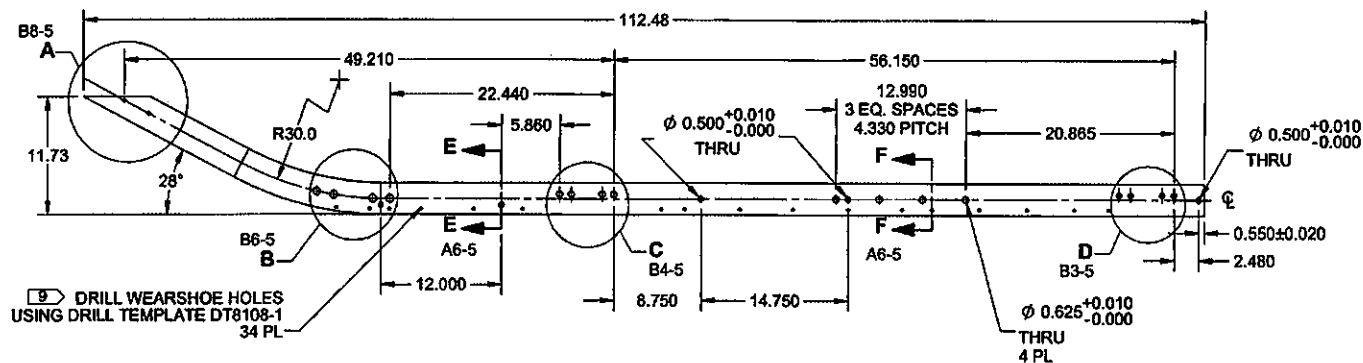
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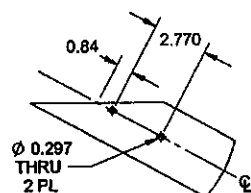
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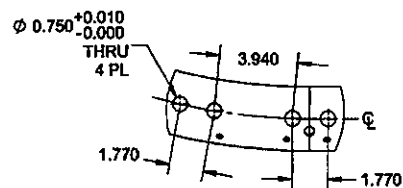
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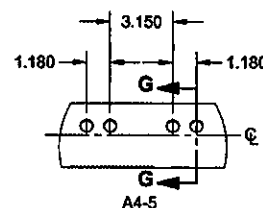
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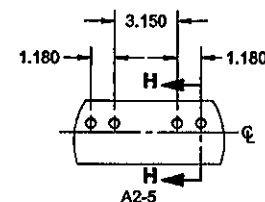
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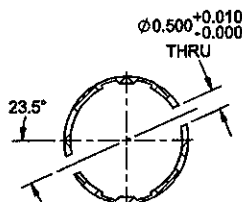
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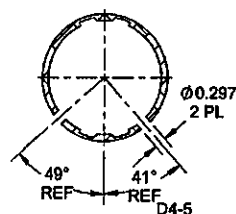
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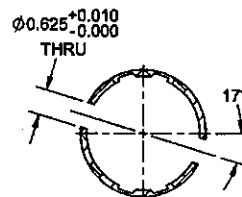
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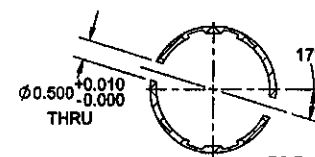
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SECTION F-F
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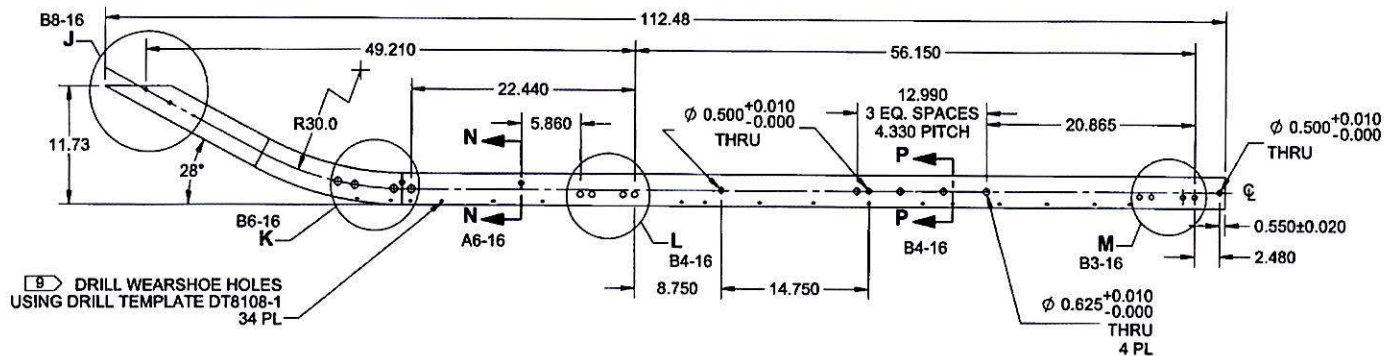
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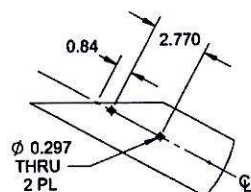
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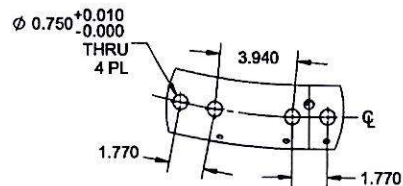
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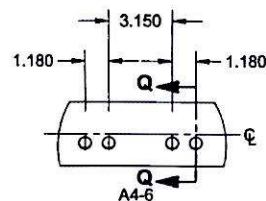
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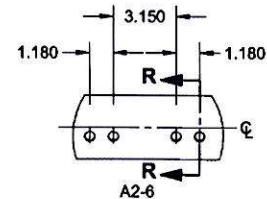
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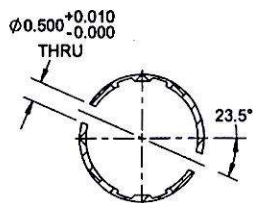
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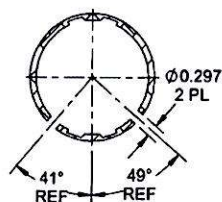
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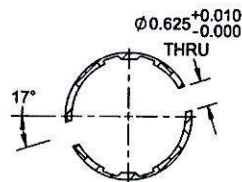
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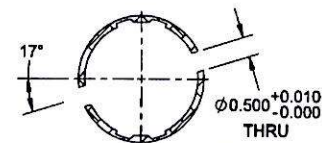
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SECTION P-P
SCALE 4X, 17 PL



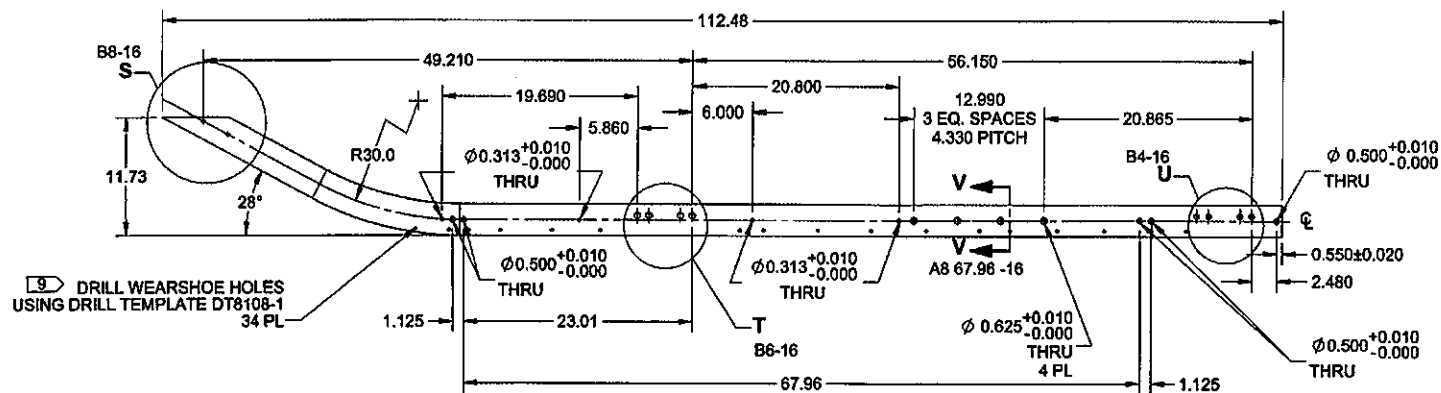
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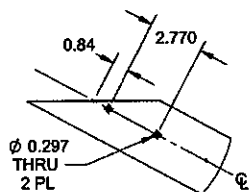
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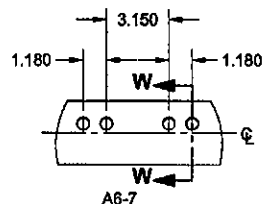
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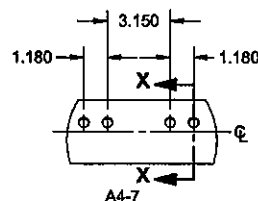
D2750-3 LH SKIDTUBE



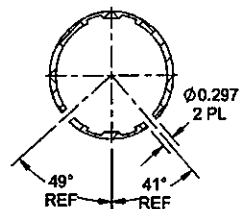
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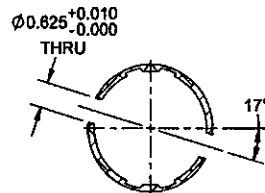
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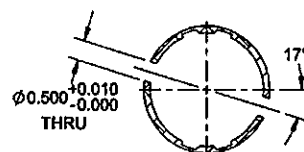
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SECTION V-V
SCALE 4X, 17 PL



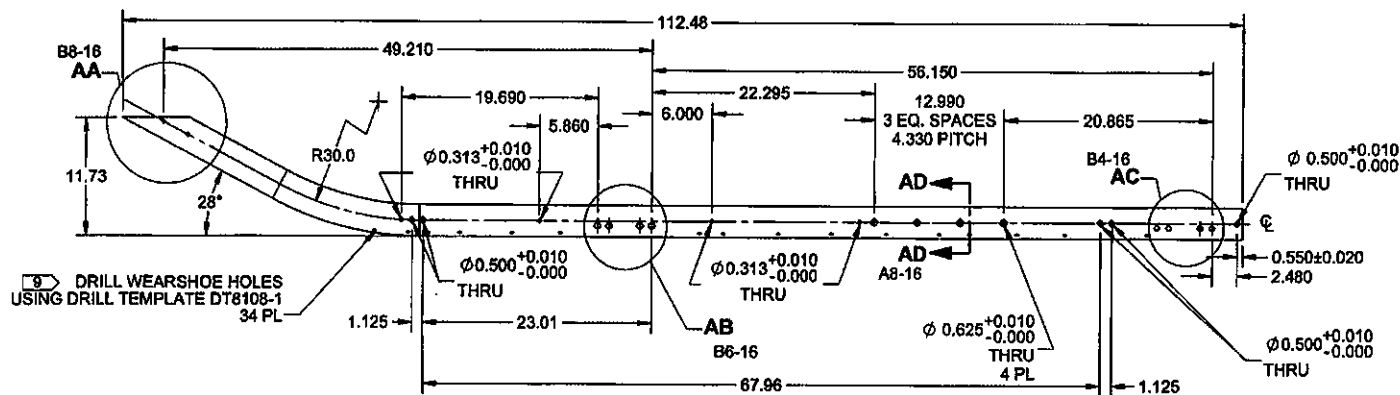
SECTION W-W
SCALE 4X, 4 PL



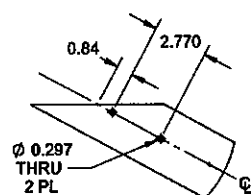
SECTION X-X
SCALE 4X, 4 PL

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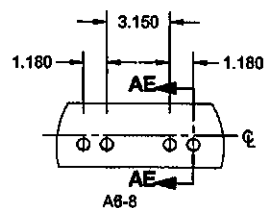
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MFG. APPR.	DD	D2750	SHEET 7 OF 16
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DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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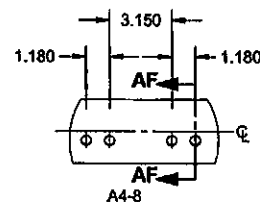
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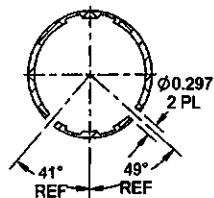
DETAIL AA
SCALE 2X



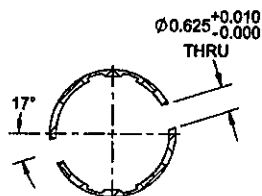
DETAIL AB
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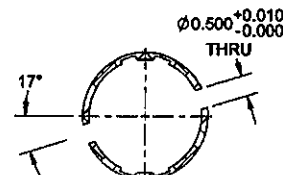
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 4X, 17 PL



SECTION AE-AE
SCALE 4X, 4 PL



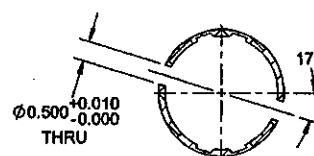
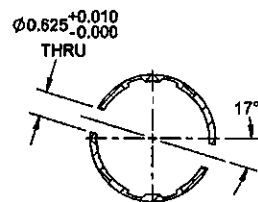
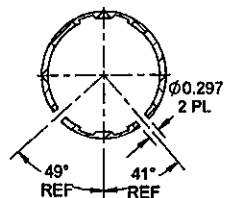
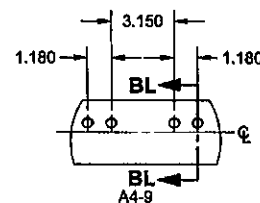
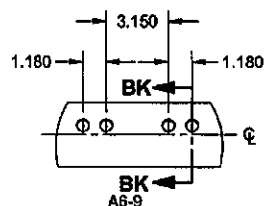
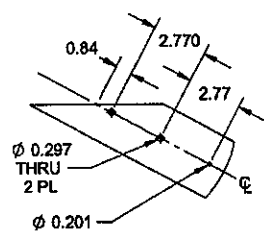
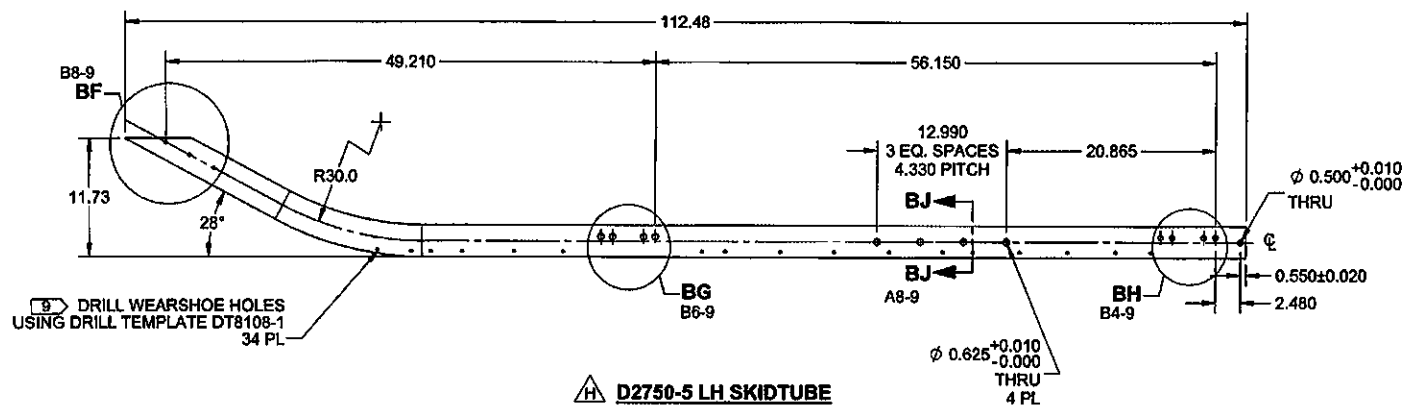
SECTION AF-AF
SCALE 4X, 4 PL

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DATE	DS	18.03.05	

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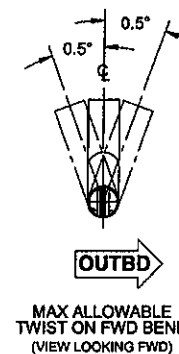
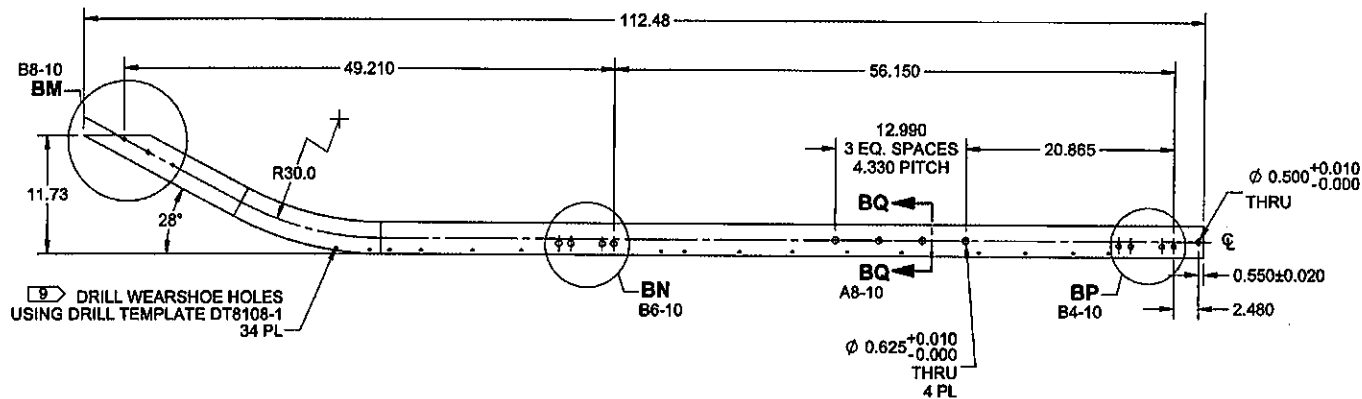
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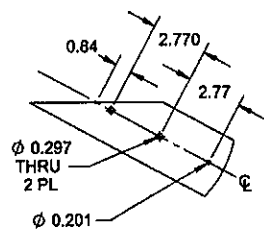
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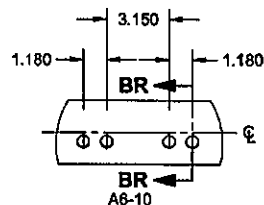
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MFG. APPR.	DD	D2750	SHEET 9 OF 16
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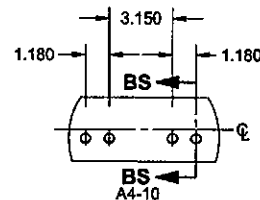
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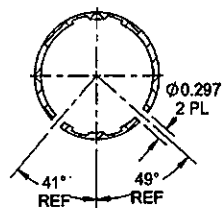
DETAIL BM
SCALE 2X



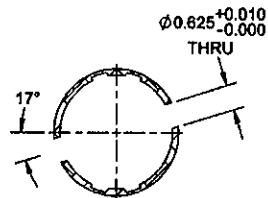
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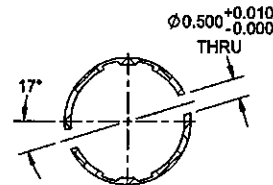
DETAIL BP
SCALE 2X



SECTION BQ-BQ
SCALE 4X, 17 PL



SECTION BR-BR
SCALE 4X, 4 PL

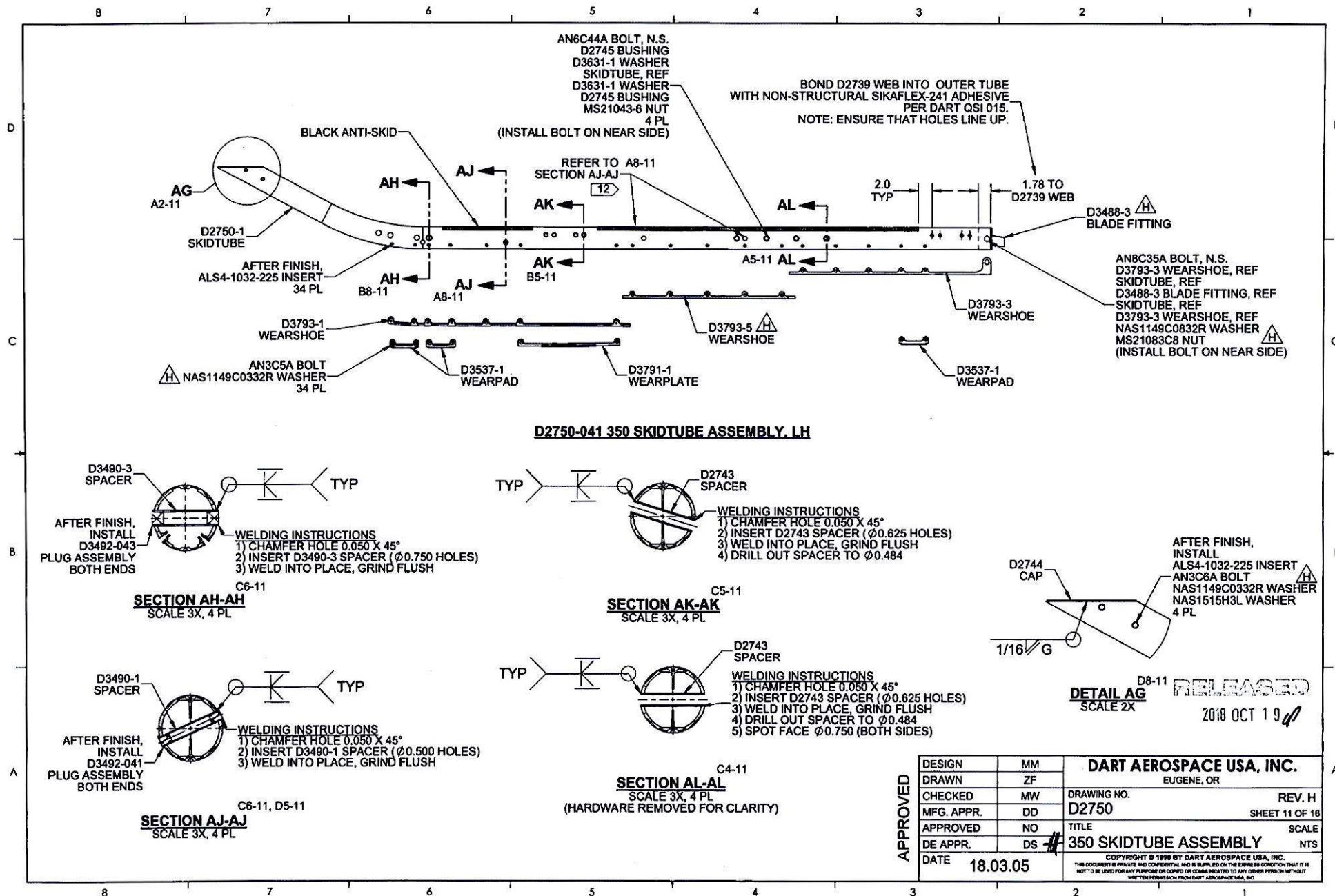


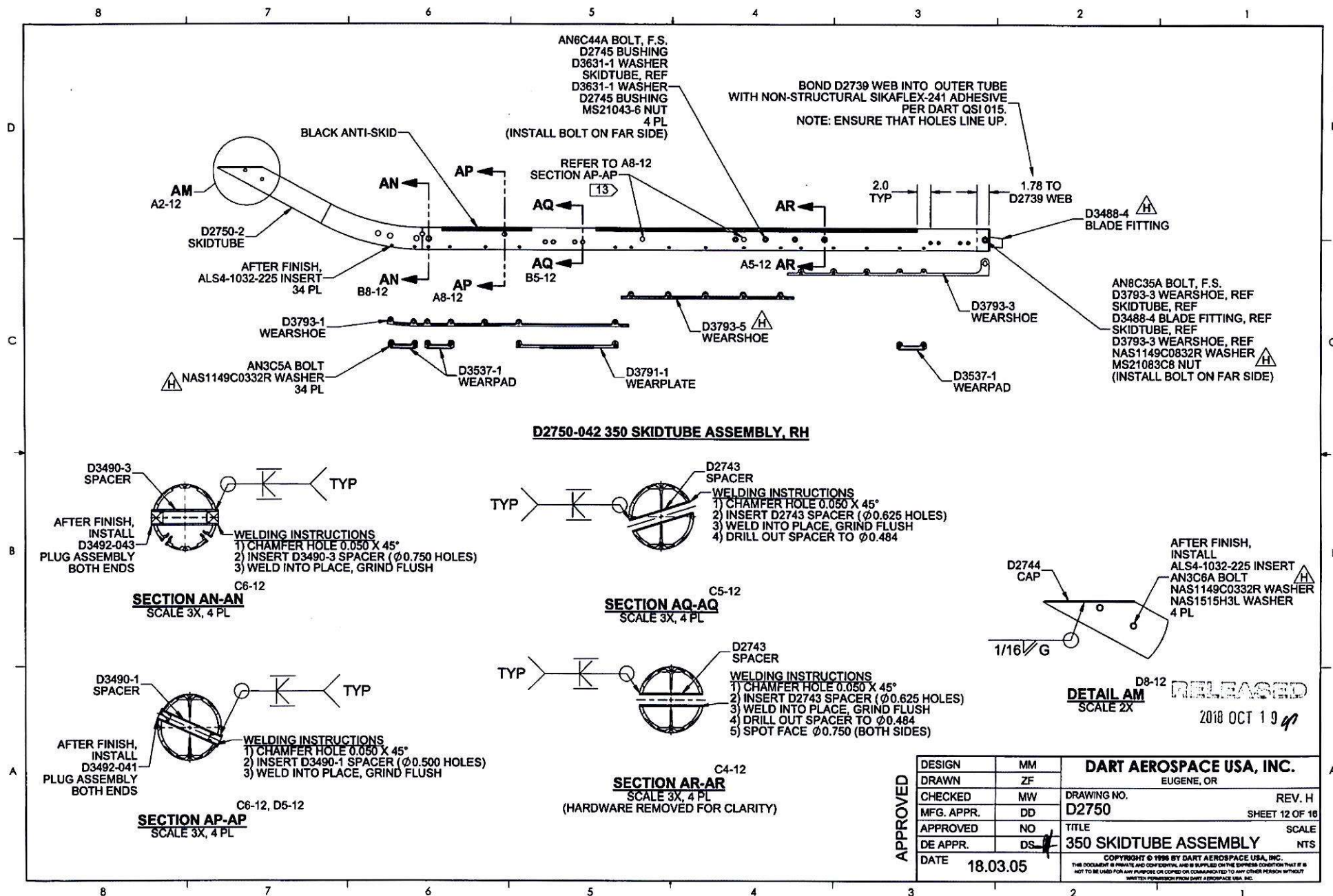
SECTION BS-BS
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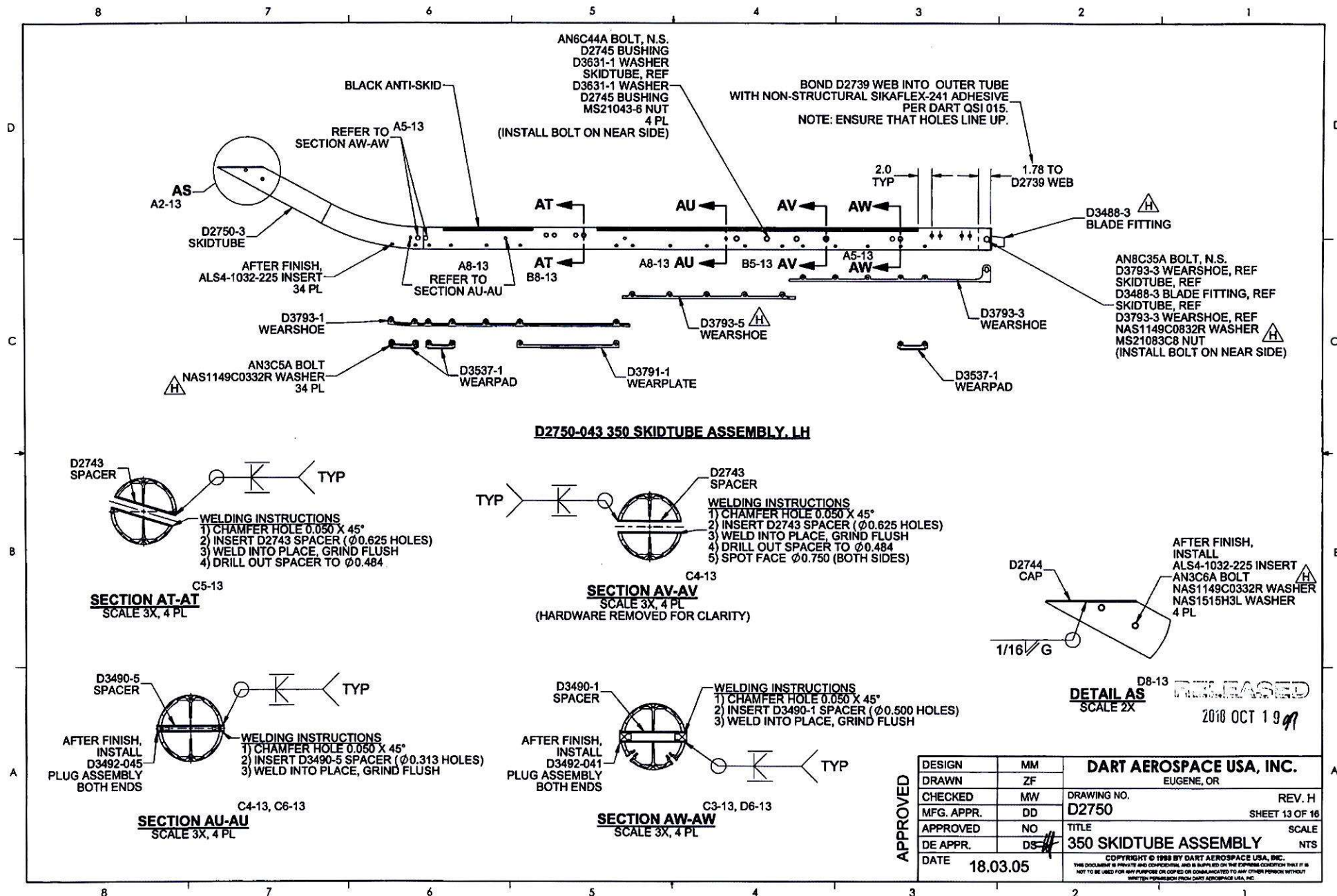
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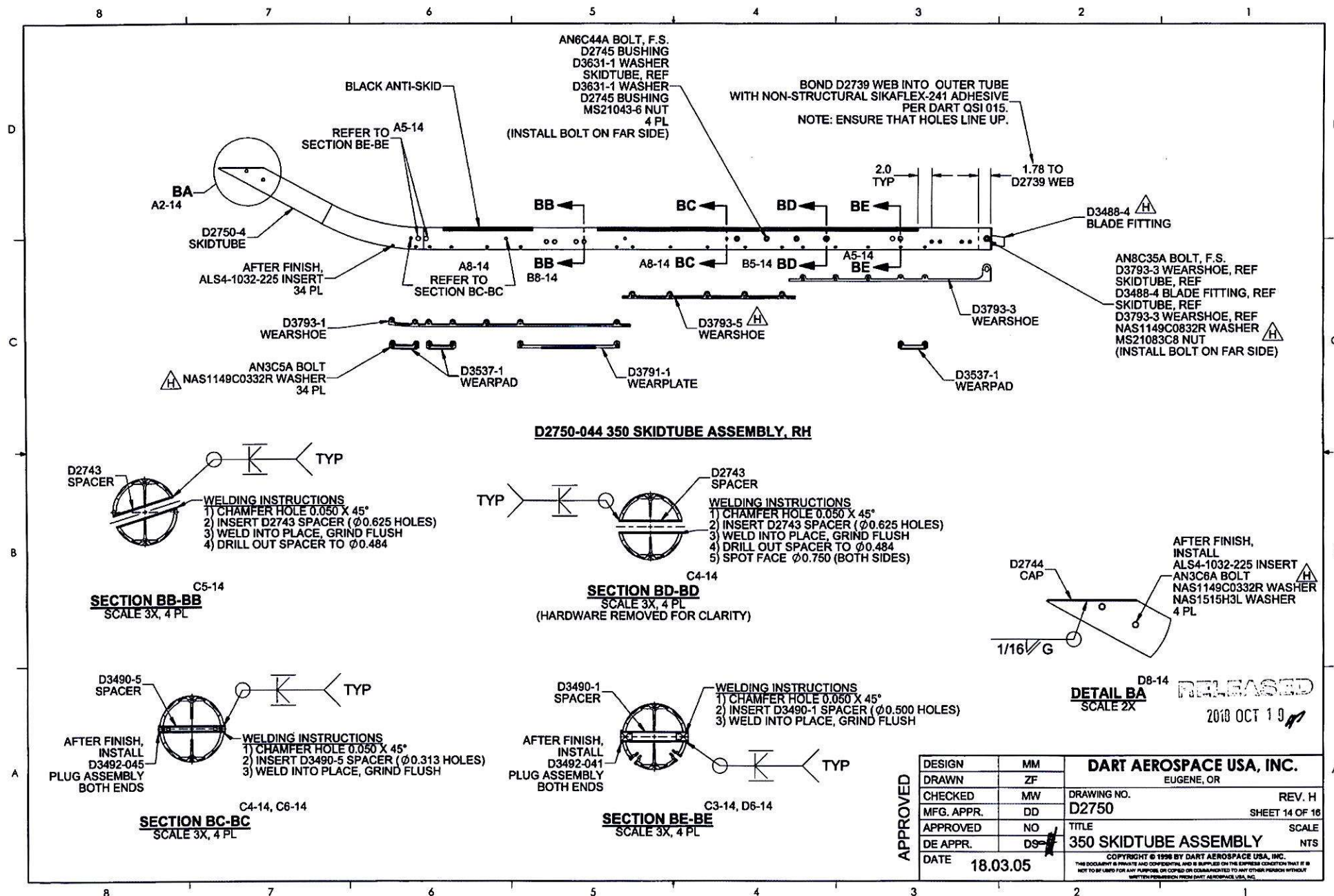
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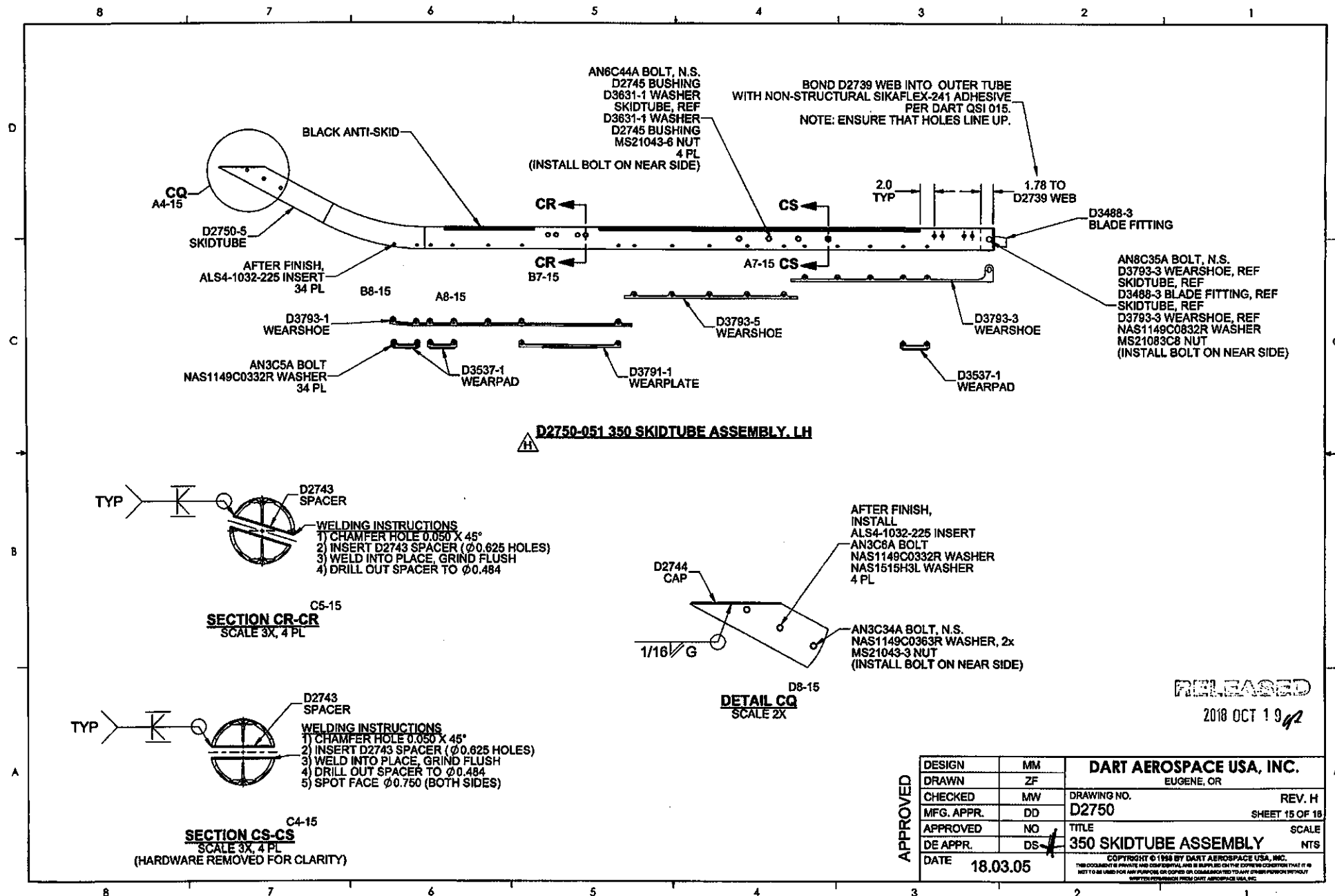
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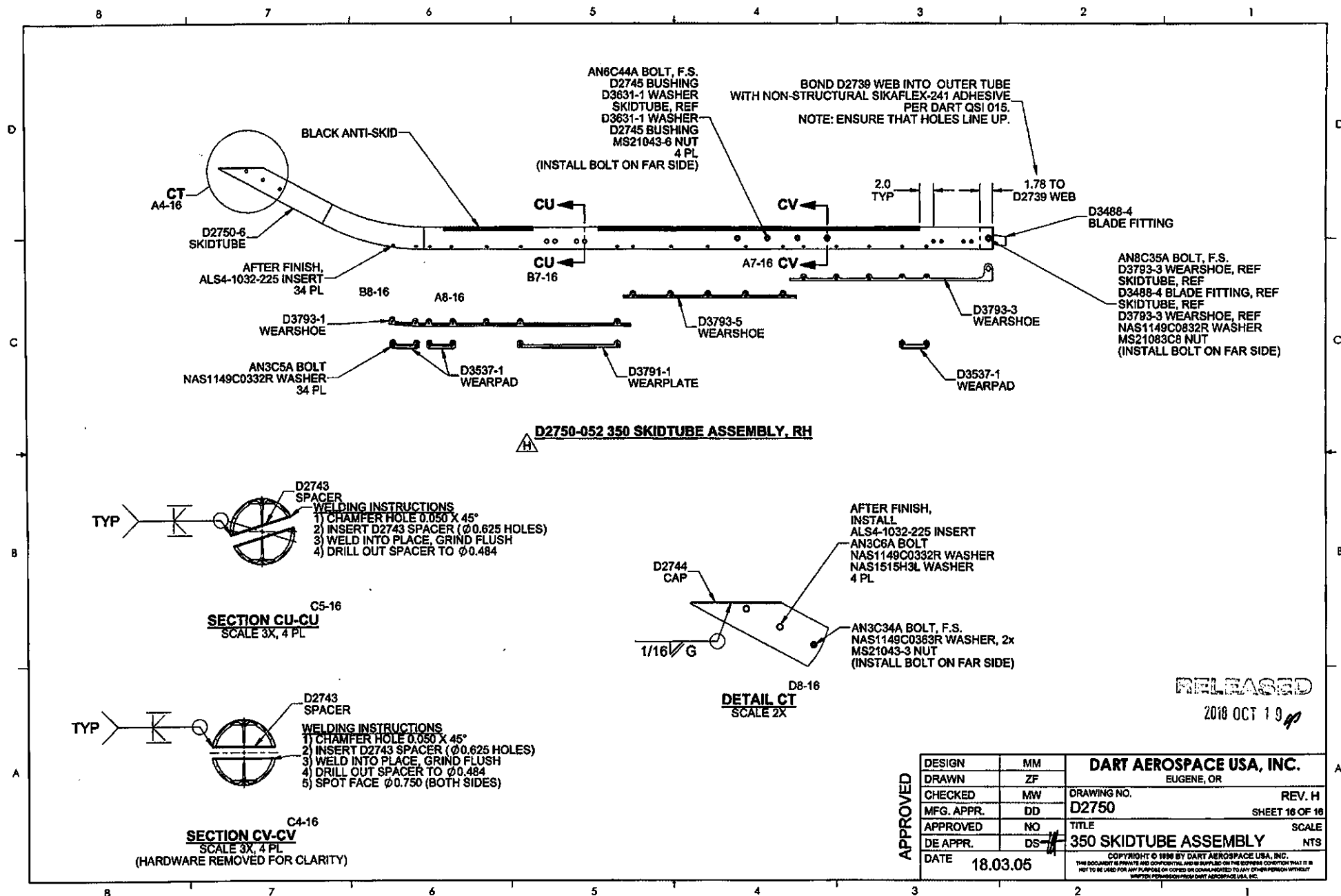












Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>209538</u> Part No. <u>D2600-3-Bent LH</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☒ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐						
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042) INSP 12 <u>4/24/24</u>		
Description Work Order Deviation				Disposition				
<u>27°</u> Bend angles are between <u>27°</u> and <u>28.9°</u> . <u>27.1°</u> <u>28.9°</u>				<u>Acceptable. Negligible (~0.011") effect on location of step holes.</u>				Completed By <u>4/24/24</u> Lead hand / Supervisor DAS 03 3-89 <u>20.6.24</u> QC / QA Coordinator DAS 03 3-89 JUN 24 2020
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☒ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
		Other/Details: _____						